

Date: Thursday, 15/01/2009 11:13:31 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 44784	Part Number	: D3355047 <i>FR</i>
Estimate Number	: 12050	Drawing Number	: D3355 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 15/01/2009 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 30/01/2009
Previous Run	: 44310	Qty:	<i>6</i> Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 09.01.15</u>		
Comment	: est rev A 06.01.20 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33555	Medium Tubing
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

Qty	Part number	Description	Batch
1	D3355-5	medium tubing	<i>B 44900 = 4x</i>

*B 44252 = 2x*

*SP 09.05.5*

2.0	D33557	Small Tubing
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

Qty	Part number	Description	Batch
1	D3355-7	small tubing	<i>B 44253 = 6x</i>

*B 44253 = 6x*

*SP 09.05.5*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 Weld assembly as per dwg

*SP 09.05.5*

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

*PD 09.05.05 (6)*

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

*802/05/05 (X6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 15/01/2009 11:13:32 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 44784

Part Number: D3355047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 102391



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:55

OVEN TEMPERATURE:

320°

FINISH TIME:

9:25

FX 09/05/06

(6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-06

(6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Caul

JS 09/05/07

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

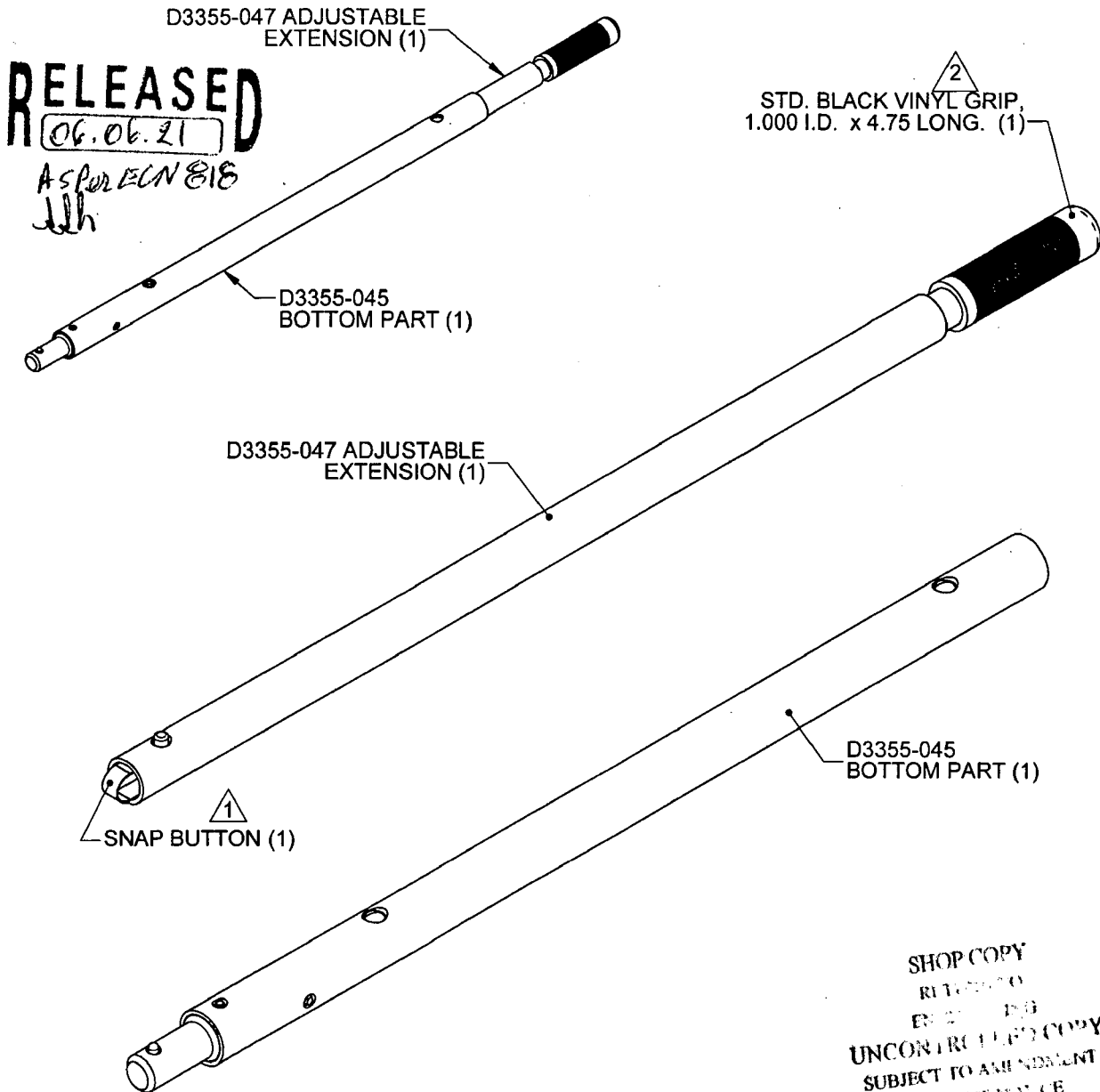
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	



**NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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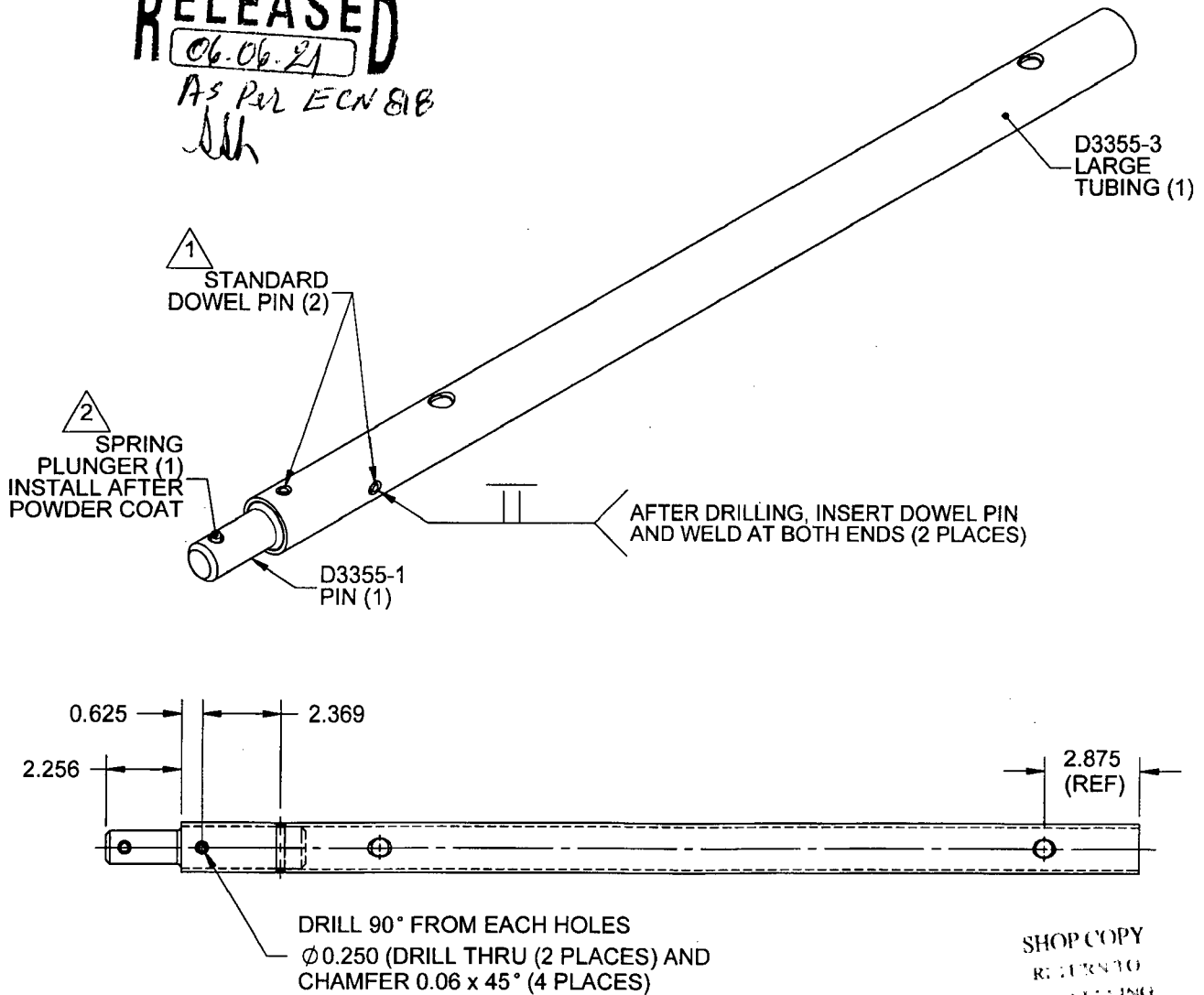
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

**RELEASED**  
**06-06-21**

AS PER ECN 818

*[Signature]***D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø 0.250 X 1.50 LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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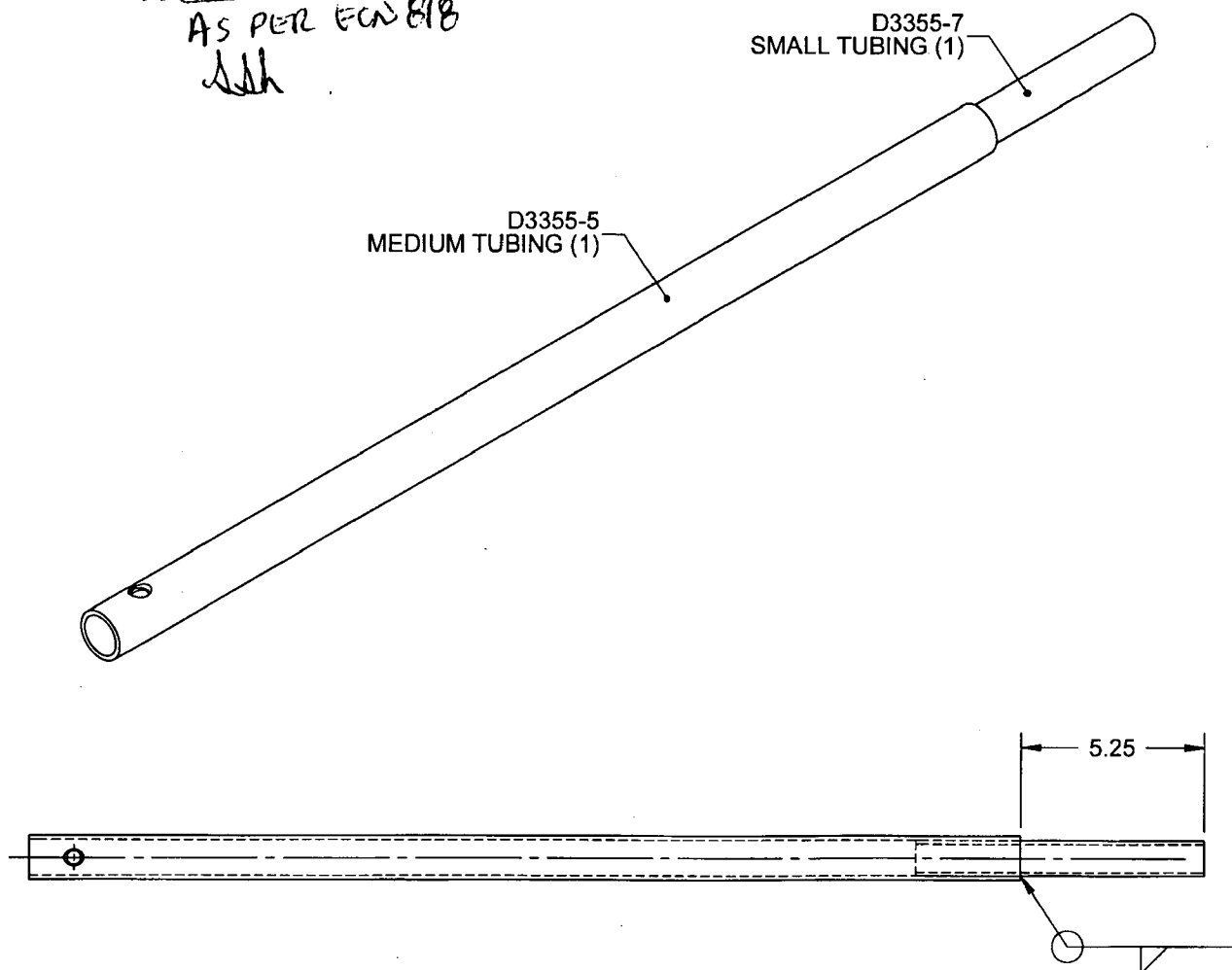
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

**RELEASED**  
**06.06.21**

AS PER ECN 818  
*[Signature]*



**D3355-047 ADJUSTABLE EXTENSION**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 0054.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

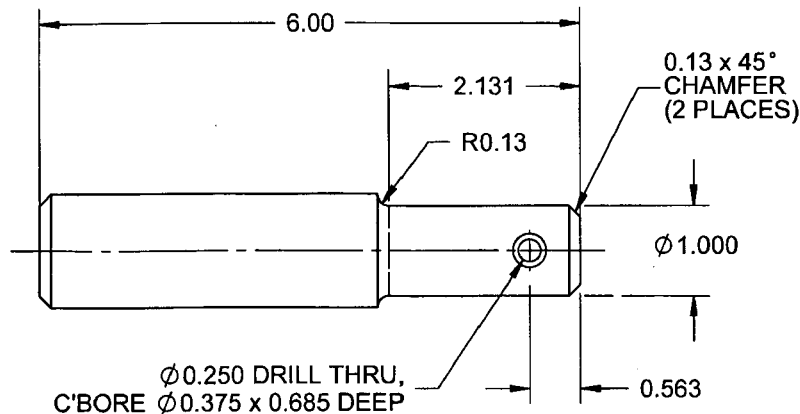
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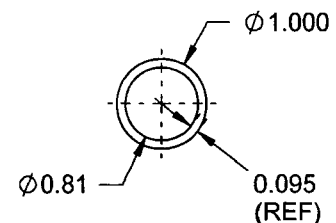
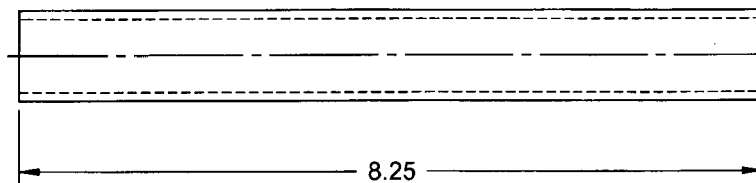
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:2

**RELEASED**  
*06.06.21*  
*AS PER ECN 010***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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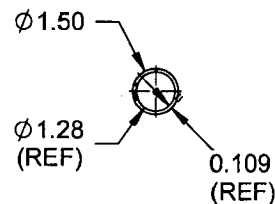
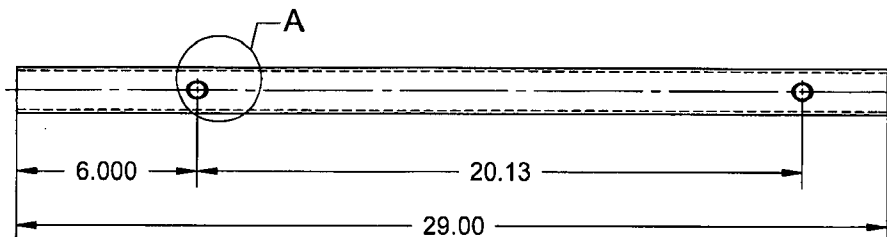


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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:6

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
**SCALE 1 : 2**



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

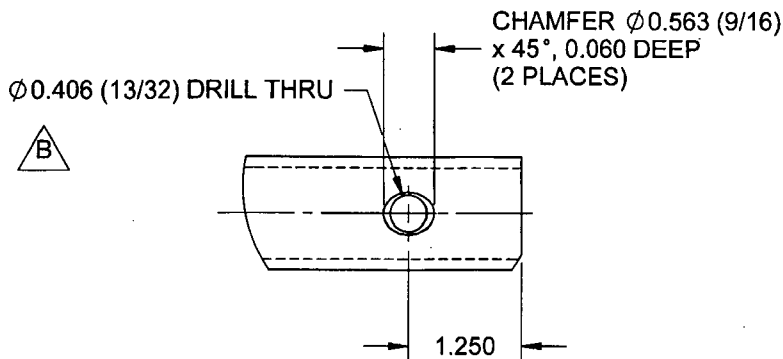
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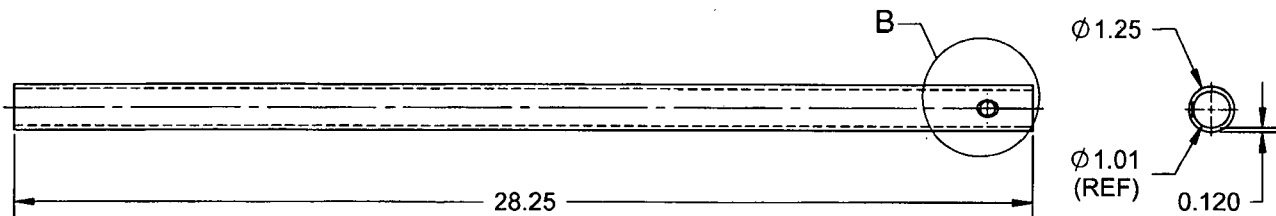
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5



**DETAIL B  
SCALE 1 : 2**



**D3355-5 MEDIUM TUBING**

**NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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